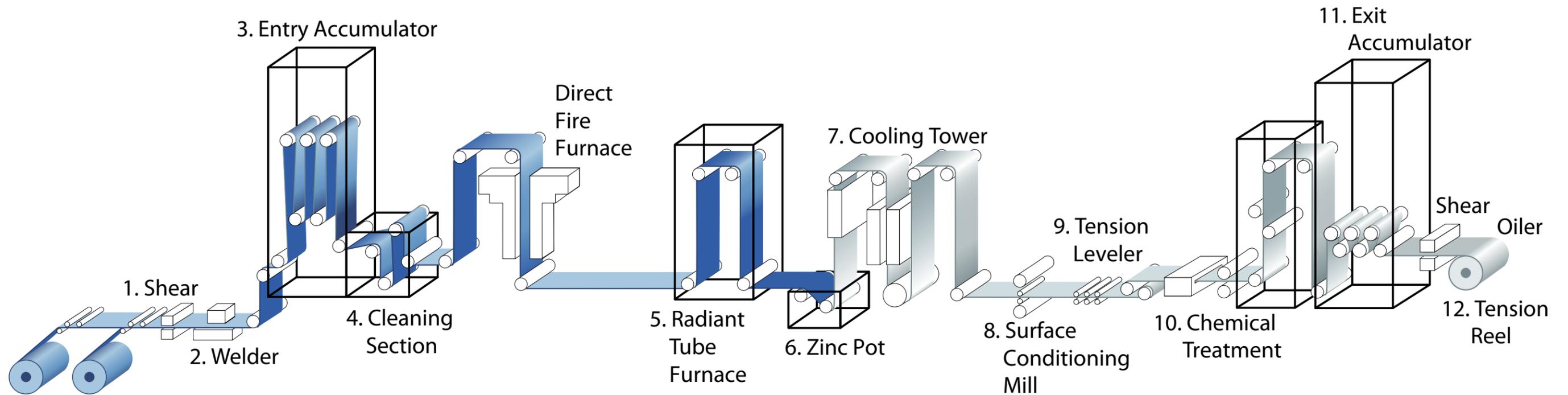


Metallic Coating Line

Manufacturer of the Metallic Coating Line: Danieli Wean



1) The coil is delivered from the cold rolling mill to one of two payoff reels on the coating line. The ends of each coil are sheared. The new ends must be welded together to create a continuous band of steel.

2) The tail of one coil and the head of the next are welded together using an electric seam welder.

3) The steel enters the first accumulator tower.

4) The steel is cleaned, rinsed and dried.

5) The cold steel band enters the furnace. The purpose of the furnace is to do one final cleaning of the surface, and to heat the steel to develop the proper mechanical properties.

6) The steel goes straight from the furnace into the coating pot. After it is coated, the steel passes through the pair of "air knives," where a high-pressure blast of air strips off the excess coating. The air knives work in conjunction with a computer-controlled gauge to create the customer's specified coating thickness.

7) The steel runs through a cooling tower so that the strip is almost back to room temperature.

8) At the customer's request, the steel can be run through a surface-conditioning mill to create a smooth surface for painting.

9) The tension leveler stretches the steel while passing over a series of rollers to provide superior flatness.

10) Any steel that is not destined for the paint line receives a chemical treatment that provides interim protection against staining during storage.

11) The steel enters the exit accumulator, waiting to be coiled again.

12) The steel is re-coiled onto the tension reel and sent for painting or packaging.